

# Work Order ID 119940

\*119940\*

Page 1

May-30-14 8:42:17 AM

Item ID: D350-636-018

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Run Start

\*NR1\*

Stop

\*NR2\*

Approvals: Process Plan: MLJ Date: 14-05-30 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4168-044	B

*M.D.*

100

Document Control

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy blue file and type labels per PPP D350-636-018 CHG 005

BAS  
08  
0-99

AUG 12 2014

AUG 12 2014  
*Mh*

FWD BEND 89.5° 8E14-06-13

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Item ID: D350-636-018

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

**\*110\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168

3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.

\*\*\*ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE\*\*\*

Drill pilot holes using drill Jig DT8150 &amp; DT8864A for first side only DT8864B for second side section BE-BE and BC-BC

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill fwd step holes using DT9616 detail AA . Ensure proper positioning.

6-Drill pilot holes for wearplates as per Dwg D4168 using DT9678. Locating from 66.54" holes.

7-Open up holes of Detail A to 0.297" (total of 2 holes per side) +.201"(total of 1 hole per side)

8-Weld D2744 Cap as per Dwg D4168 and QSI 004.Fill grooves in bend left from bending as per QSI 004

BE14-06-13

BE14-06-16

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Item ID: D350-636-018 Accept \*N900040100\* Setup Start \*NS1\*

Revision ID: Stop \*NS2\*

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00 \*1\* Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 \*1\* Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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A/R Aluminum Rod batch: m129285

9-Grind welds flush as per Dwg D4168

7BE140616

120	QC10- Inspect visual per QSI004- ground welds	0.00							
-----	---	------	--	--	--	--	--	--	--

\*120\*

QC

Memo

0.00

SHP  
14/6/16

Quality Control

130	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

\*130\*

QC

Memo

0.00

SHP  
14/6/16

Quality Control



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Item ID: D350-636-018

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**\*N900040100\***

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Revision ID:

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**\*NS2\***

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/30/14

Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

0.00

**\*160\***

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes using hole saw of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168.

2-Open up holes of wearplate holes to 0.375" section CK-CK (total of 4 holes per side) 0.3125" holes section BC-BC (4 per side) as per dwg D4168.

3- Open float using uni-bit hole to 0.500" (4 per side)

4-Chamfer holes dwg D4168 (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI015 let cure for 12hrs.

A/R Sikaflex-291

batch:

128569  
exp. date: 14/11/20

8- Weld spacers as per dwg D4168 & QSI004 (welding instructions on sheet 11)

A/R Aluminum Rod

batch:

129285 BE14/06/19

9- Grind welds flush as per Dwg D4168

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168

DC 14/06/17

14-6-19

14-6-20

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Item ID: D350-636-018

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11- C'bore section CK-CK. ADJUST TOOLING AS REQUIRED.

VERF BY: BE

12- Deburr holes, ensure tube is free of all scratches before sending to paint.

\*\*\*\*\* FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING

HOLE IN TUBE \*\*\*\*\*

\*\*\*\*\*REF TO W/O BATCH: \_\_\_\_\_\*\*\*\*\*

170

QC10- Inspect visual per QSI004- ground welds

0.00

DAS

27

9-89

\*170\*

QC

Memo

0.00

Quality Control

14/6/24

180

QC5- Inspect part completeness to step on W/O

0.00

DAS

27

9-89

\*180\*

QC

Memo

0.00

Quality Control

14/6/24

# Work Order ID 119940

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May-30-14 8:42:17 AM

Item ID: D350-636-018 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible  
 Start Date: 5/30/14 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 5/30/14 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				1	76	14-7-3	
*190*									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00				1	CR	14-7-5	
*200*									
SprayPaint	Memo	0.00							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 128975								
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 129977								
210	QC14- Inspect Spray Paint	0.00				1B+1	d	90	11/03/29
*210*									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

DAS  
15  
9-89

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Stop \*NS2\*

Start Date: 5/30/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

0.00

\*230\*

HandFinishing

0.00

HandFinish

Memo

Hand Finishing

1- Install inserts as per Dwg D4168

2-Inspect for Foreign Objects

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M129693

EXP DATE: 12/12

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: M121621 RTV 598 M125792 exp 15/10

5-Coat all exposed fasteners with "LPS Procyon" batch: M12290

240

QC5- Inspect part completeness to step on W/O

0.00

\*240\*

QC

Memo

0.00

Quality Control

DAS  
16  
9-89

14/07/06

1211 J 111 1408506



# Work Order ID 119940

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Item ID: D350-636-018

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 5/30/14

Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Run Start

\*NR1\*

Stop

\*NR2\*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

250

Pick Kit

0.00

\*250\*

Packaging

Memo

0.00

Packaging

IX

DAS  
28  
9-89

AUG 12 2014

DAS  
31  
9-89

260

QC4- 100% Inspect kits for completeness

0.00

\*260\*

QC

Memo

0.00

Quality Control

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*

AUG 12 2014

DAS  
06  
9-89

270

Packaging

0.00

\*270\*

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-636-018

Location: 521

PPP rev: \_\_\_\_\_

DAS  
06  
9-89

AUG 12 2014

S

**Work Order ID 119940**

May-30-14 8:42:17 AM

**\*119940\***

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Item ID: D350-636-018

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280

QC21- Final Inspection - Work Order Release

0.00

**\*280\***

QC

Memo

0.00

Quality Control

MLJ 14-08-13

MLJ 14-08-13

# Picklist Print

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13

Work Order ID: 119940

\*119940\*

Parent Item: D350-636-018

\*D350-636-018\*

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B  
11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as per  
NCR 11-906 DD verf:EC IPP Rev:D 112.04.16 AS PER ECN 12-  
542 DD verf:EC IPP REV:E 13.08.28 PER ECN13-594 DD  
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3490-1		Manufactured	No			160	Each	115.0000	4	4			
<b>*D3490-1*</b>									**			BE 14-06-19	
Cross Bolt Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				115					
				112737				1					
				116358				114					
AN3C34A		Purchased	No			230	Each	32.0000	1	1			
<b>*AN3C34A*</b>									**			14/07/29	
BOLT													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST352				32					
				m127044				32					
AN3C36A		Purchased	No			230	Each	170.0000	4	4			
<b>*AN3C36A*</b>									**			14/07/29	
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				25					
				101261				4					
				122204				11					
				124827				10					
				ST514				145					
				m127769				5					
				m128398				65					
				m128773				75					

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Work Order ID: 119940

**\*119940\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

AN3C37A Purchased No 230 Each 386.0000 1 1

Start Qty: 1.00

Required Qty: 1.00

**\*AN3C37A\***

BOLT

DAS  
06  
9-89

Location	Loc Qty	Loc Code
ST353	10	
M124131	1	
M127823	9	
ST514	376	
M128491	176	
M128773	200	

\*\*

DAS  
28  
9-89

AUG 12 2014

DAS  
31  
9-89

129687

AN3C42A Purchased No 230 Each 40.0000 1 1

**\*AN3C42A\***

Bolt

DAS  
06  
9-89

Location	Loc Qty	Loc Code
FG	5	
121103	5	
ST353	35	
m127300	1	
m128491	9	
m128830	25	

\*\*

DAS  
28  
9-89

DAS  
31  
9-89

IX

D3488-042 Manufactured No 230 Each 12.0000 1 1

**\*D3488-042\***

Blade Fitting RH

\*\*

Location	Loc Qty	Loc Code
FP001	2	B115599
113592	1	
98887	1	
FP002	10	
112237	10	

X1

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Shop Packet Print

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Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D3490-5      Manufactured      No      230      Each      32.0000      4      4

Start Qty: 1.00

Required Qty: 1.00

**\*D3490-5\***

Cross Bolt Spacer

\*\*

BE 14-06-19

Location

Loc Qty

Loc Code

LG001

32

09104

32

D3492-1      Manufactured      No      230      Each      144.0000      8      8

**\*D3492-1\***

Plug

\*\*

11/03/29

Location

Loc Qty

Loc Code

FP001

144

111578

2

112738

8

114879

134

D3492-5      Manufactured      No      230      Each      129.0000      8      8

**\*D3492-5\***

Plug

\*\*

NIA 15/03/29

Location

Loc Qty

Loc Code

FP001

129

104854

9

105612

39

112740

81

D3873-1      Manufactured      No      230      Each      223.0000      7      7

**\*D3873-1\***

Bushing

\*\*

14/03/29

Location

Loc Qty

Loc Code

ST067

223

104858

5

105611

217

109110

1

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**\*119940\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float  
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D4154-041

Manufactured No

230

Each

4.0000

Start Qty: 1.00

1

1

Required Qty: 1.00

**\*D4154-041\***

Wearplate Assembly

\*\*

lll 11/03/29

Location

Loc Qty

Loc Code

FP002

4

B119423

41

106716

1

114212

3

D4170-1

Manufactured No

230

Each

101.0000

4

4

**\*D4170-1\***

Bushing

\*\*

8614-06-19

Location

Loc Qty

Loc Code

LG001

101

107896

101

4

D4171-1

Manufactured No

230

Each

15.0000

1

1

**\*D4171-1\***

Bushing

\*\*

lll 11/03/29

Location

Loc Qty

Loc Code

ST098

15

109144

15

11

MS21043-3

Purchased No

230

Each

528.0000

5

5

**\*MS21043-3\***

Nut

\*\*

lll 11/03/29

Location

Loc Qty

Loc Code

FG

80

103691

80

ST315

55

124555

35

m126741

20

ST509

393

m128398

393

25

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Start Date: 5/30/14

Required Date: 5/30/14

NAS1149C0363R

Purchased

No

230

Each

Start Qty: 1.00  
1,265.000 9 9

Required Qty: 1.00

**\*NAS1149C0363R\***

Washer

\*\*

*all 11/02/29*

Location

Loc Qty

Loc Code

FP001

580

114742

580

Return2014

6

114742

6

ST292

679

122441

79

m128591

600

*x 9*

NAS1515H3L

Purchased

No

230

Each

483.0000 4 4

**\*NAS1515H3L \***

Washer

\*\*

*all 11/02/29*

Location

Loc Qty

Loc Code

FG

40

102472

40

ST297

443

m127831

159

m128976

284

*x 4*

NAS1611-005

Purchased

No

230

Each

171.0000 8 8

**\*NAS1611-005\***

O-RING

\*\*

*pln PTO last page -7*

Location

Loc Qty

Loc Code

FP001

171

m126974

96

m129198

75

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Start Date: 5/30/14

Required Date: 5/30/14

NAS1611-010

Purchased

No

230

Each

195.0000

Start Qty: 1.00

8

8

Required Qty: 1.00

**\*NAS1611-010\***

O-RING

**\*\***

*ell 1107/20*

Location

Loc Qty

Loc Code

FP001

195

11129523

m126988

3

*x 8*

m127813

4

m128375

80

m128388

8

m129198

100

NAS1149D0863J

Purchased

No

250

Each

859.0000

2

2

**\*NAS1149D0863.J\***

Washer

**\*\***

DAS  
28  
9-89

AUG 12 2014

Location

Loc Qty

Loc Code

FP001

2

118078

2

ST293

57

125484

57

*2x*

ST510a

800

125268

600

125635

200

DAS  
06  
9-89

D2744

Manufactured

No

110

Each

21.0000

1

1

**\*D2744\***

Cap

**\*\***

*BR1406-16*

Location

Loc Qty

Loc Code

LG001

21

115440

21

May-30-14 8:42:20 AM

Shop Packet Print

Page 6



# Picklist Print

May-30-14 8:42:20 AM

Page 7

Work Order ID: 119940

**\*119940\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D2600-3-BENT

Manufactured No

110

Each

8.0000

Start Qty: 1.00

1

1

Required Qty: 1.00

**\*D2600-3-BENT\***

Extrusion Bent

**\*\***

BE 14-06-13  
B120571 x1

Location

Loc Qty

Loc Code

LG

7

117904

7

LG002

1

112976

1

D2743

Manufactured No

160

Each

124.0000

8

8

**\*D2743\***

Crossbolt Spacer

**\*\***

BE 14-06-19

Location

Loc Qty

Loc Code

LG

123

111570

8

112729

115

LG001

1

109799

1

D2739

Manufactured No

160

Each

12.0000

1

1

**\*D2739\***

350 I Beam

**\*\***

12/14/06/17

Location

Loc Qty

Loc Code

LG

5

111094

1

113252

1

117803

3

LG002

7

115881

7

# Picklist Print

May-30-14 8:42:20 AM

Page 8

Work Order ID: 119940

**\*119940\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float  
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

ALS4-1032-225 AELS8-1032-225 Purchased No 230 Each 765.0000 Start Qty: 1.00 4 4 Required Qty: 1.00

**\*ALS4-1032-225\***

Rivnut

**\*\***

*Handwritten: 11/07/29*

Location	Loc Qty	Loc Code
FG	30	
M127028	30	
FP001	461	
M128649	461	
ST280	248	
M127028	10	
M128179	238	
st555	26	
M127092	26	

*Handwritten: X4*

AN8C35A Purchased No 230 Each 55.0000

**\*AN8C35A\***

Bolt

**\*\***

*Handwritten: 11/07/29*

Location	Loc Qty	Loc Code
FG	4	
121275	4	
FP001	51	
m126293	29	
m127823	22	

*Handwritten: V1*

# Picklist Print

May-30-14 8:42:20 AM

Page 9

Work Order ID: 119940

**\*119940\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

AN6C44A

Purchased

No

230

Each

127.0000

Start Qty: 1.00

4

4

Required Qty: 1.00

**\*AN6C44A\***

Bolt

\*\*

*lll 11/07/24*

Location

Loc Qty

Loc Code

FG

2

103964

2

ST341

28

m128319

28

ST505

97

m128700

47

m129199

50

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
*x4*  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

MS21083C8

Purchased

No

230

Each

161.0000

1

1

**\*MS21083C8\***

Nut

\*\*

*lll 11/07/24*

Location

Loc Qty

Loc Code

ST319

11

m127255

5

m128119

6

ST508

150

m128798

150

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
*x1*  
\_\_\_\_\_

D3631-1

Manufactured

No

230

Each

180.0000

8

8

**\*D3631-1\***

Washer

\*\*

*lll 11/07/24*

Location

Loc Qty

Loc Code

FP001

180

110258

16

111019

12

115800

52

119553

100

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
*x2*  
\_\_\_\_\_

# Picklist Print

May-30-14 8:42:20 AM

Work Order ID: 119940

**\*119940\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

NAS1149C0332R

Purchased

No

230

Each

Start Qty: 1.00  
5,700.000 4 4

Required Qty: 1.00

**\*NAS1149C0332R\***

WASHER

**\*\***

*del 11/02/14*

Location

Loc Qty

Loc Code

GA

825

*11124909*

125654

825

*x 4*

Return2014

41

122063

41

ST292

1676

124580

8

125654

8

m128591

1660

st510

3158

m126319

61

m127306

2500

m127410

563

m127831

34

D2745

Manufactured

No

230

Each

78.0000

8

8

**\*D2745\***

Bushing

**\*\***

*del 11/07/14*

Location

Loc Qty

Loc Code

ST017

78

*13117099*

107336

4

*x 8*

111554

8

113176

58

90323

2

93336

6

# Picklist Print

May-30-14 8:42:20 AM

Work Order ID: 119940

**\*119940\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

NAS1149C0832R Purchased No 230 Each 290.0000 Start Qty: 1.00 1 1

**\*NAS1149C0832R\***

Washer

\*\*

*ll* 14/07/29

Location	Loc Qty	Loc Code
ST292	290	
122441	23	
m114915	117	
m125807	150	

*xl*

AN3C6A Purchased No 230 Each 1,265.0000 4 4

**\*AN3C6A\***

Bolt

\*\*

*ll* 14/07/29

Location	Loc Qty	Loc Code
FG	10	
122416	10	
ST351	2	
m128224	2	
ST513	1253	
m125709	257	
m128769	996	

*xl*

MS21043-6 Purchased No 230 Each 218.0000 4 4

**\*MS21043-6\***

NUT

\*\*

*ll* 14/07/29

Location	Loc Qty	Loc Code
FG	20	
103693	20	
ST315	10	
m127255	10	
ST509	188	
m127813	188	

*xl*

# Picklist Print

May-30-14 8:42:20 AM

Page 12

Work Order ID: 119940

**\*119940\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float  
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D3493-1

Manufactured No

250

Each

199.0000

Start Qty: 1.00

2

2

Required Qty: 1.00

**\*D3493-1\***

Washer

DAS  
06  
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST051

189

109105

159

112741

30

\*\*

DAS

28

9-89

AUG 12 2014

DAS

31

9-89

MS21083C8

Purchased

No

250

Each

161.0000

2

2

**\*MS21083C8\***

Nut

DAS  
06  
9-89

Location

Loc Qty

Loc Code

ST319

11

m127255

5

m128119

6

ST508

150

m128798

150

\*\*

DAS

28

9-89

DAS

31

9-89

AN8C21A

Purchased

No

250

Each

49.0000

2

2

**\*AN8C21A\***

Bolt

DAS  
06  
9-89

Location

Loc Qty

Loc Code

ST

2

123966

2

ST341

2

m127061

2

ST342

3

m128319

2

m128849

1

ST508

42

m127823

42

\*\*

DAS

28

9-89

DAS

31

9-89

May-30-14 8:42:20 AM

Shop Packet Print

Page 12

# Picklist Print

May-30-14 8:42:20 AM

Work Order ID: 119940

**\*119940\***

Parent Item: D350-636-018

**\*D350-636-018\***

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float  
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D2741

Manufactured No

250

Each

34.0000

Start Qty: 1.00

Required Qty: 1.00

1 1

**\*D2741\***

Blade

**\*\***

DAS  
28  
9-89

**AUG 12 2014**

DA:  
3  
9-8

DAS  
06  
9-89

Location

Loc Qty

Loc Code

FG	14	
100664	5	
115522	5	
98323	4	
FP001	1	
88824	1	
ST466	19	
107206	2	
113640	12	
115522	5	

118387  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1	1	1	1	D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

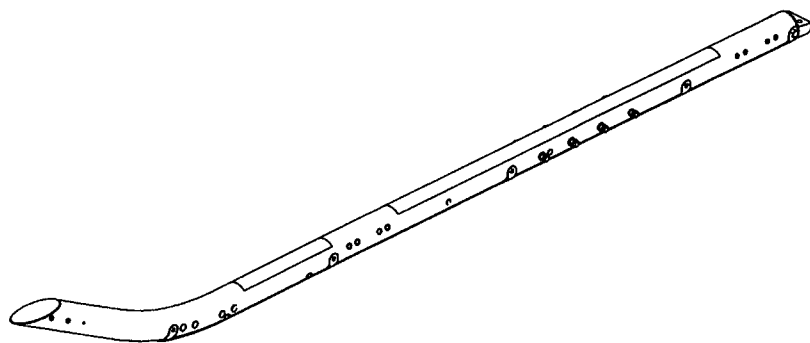
WITHOUT NOTICE  
WORK ORDER  
NO. 119940 MLC  
14-05-30

#### GENERAL NOTES:

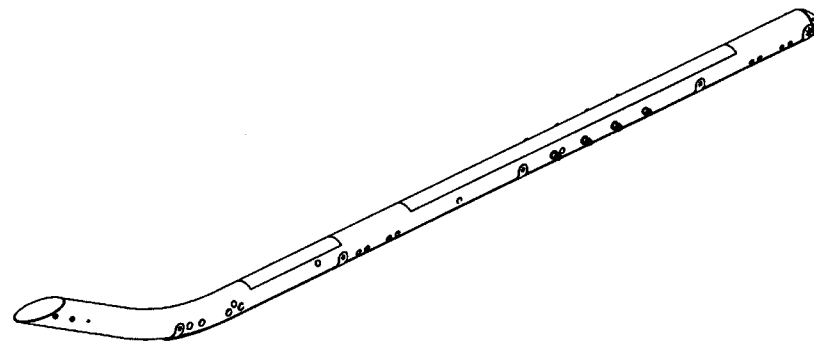
- MATERIAL: MAKE D4168-1/2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2  
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (2N D-1-41-5/6-7). UPDATED FINISH OPTIONS. REASON: PART13-276 AND NCR13-2757	MB	13.07.11
A	NEW ISSUE	SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	JP	KENT, WA	
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D4168	SHEET 1 OF 11
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	





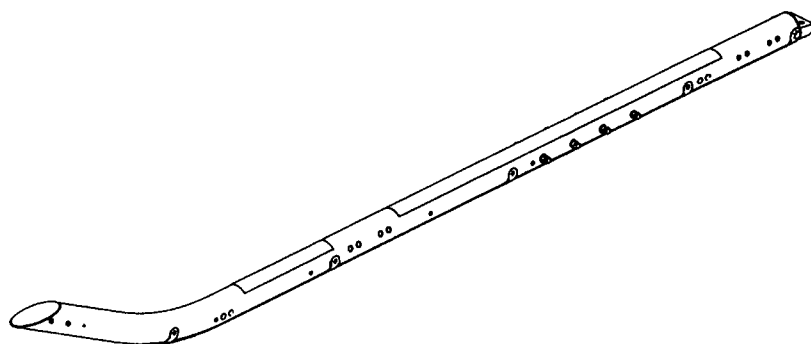
**D4168-041 350 SKIDTUBE ASSEMBLY, LH**



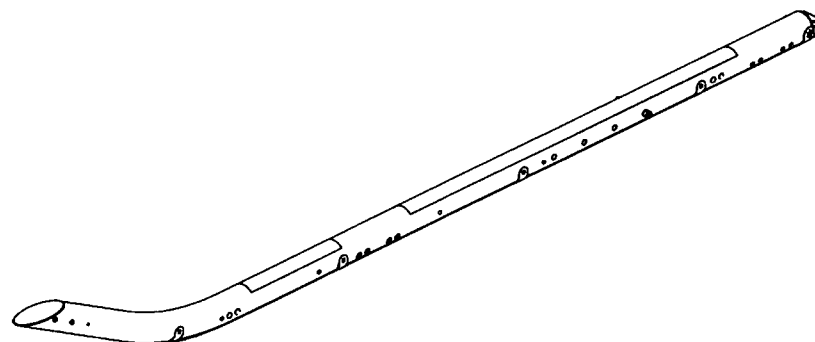
**D4168-042 350 SKIDTUBE ASSEMBLY, RH**

**RELEASED**  
2013-08-13  
*AW*

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4168	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



**D4168-043 350 SKIDTUBE ASSEMBLY, LH**

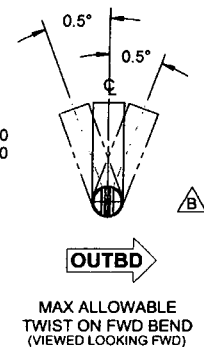
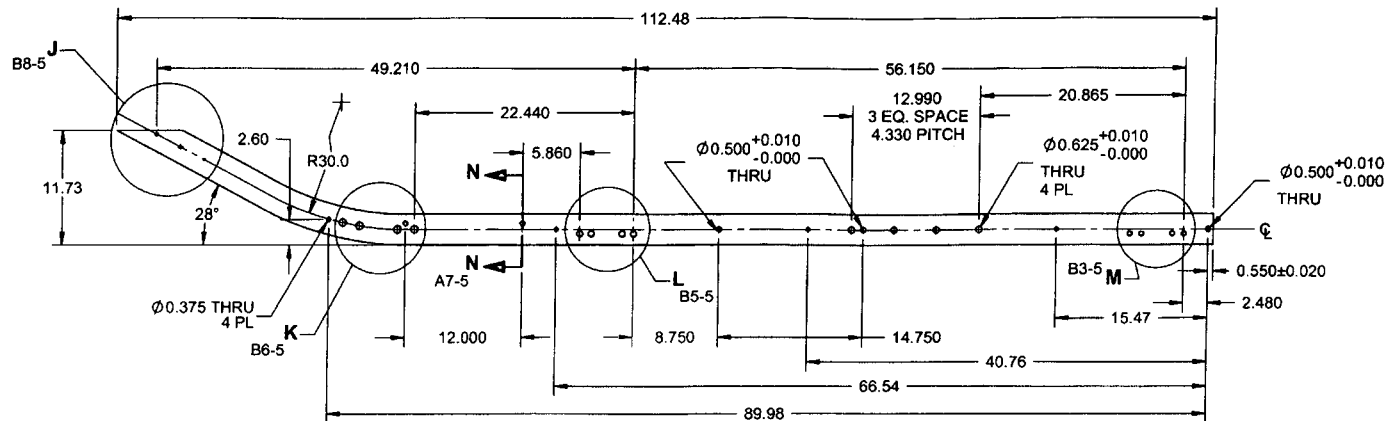


**D4168-044 350 SKIDTUBE ASSEMBLY, RH**

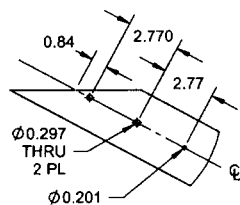
**RELEASED**  
2013-08-13  
MMD

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	JB	KENT, WA	
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D4168	SHEET 3 OF 11
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

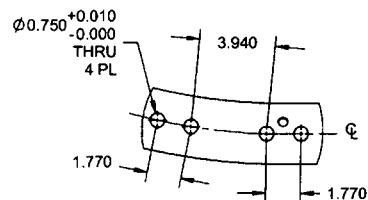




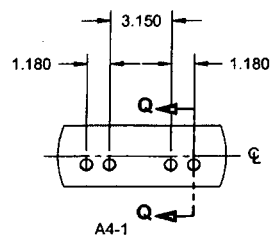
### D4168-2 RH SKIDTUBE



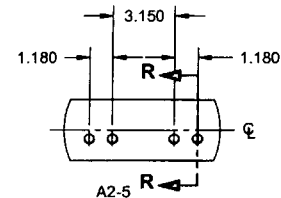
**DETAIL J**  
SCALE 2X



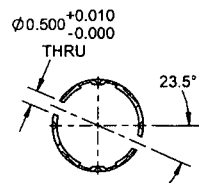
**DETAIL K**  
SCALE 2X



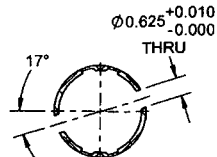
**DETAIL L**  
SCALE 2X



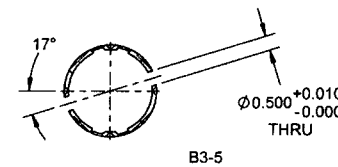
**DETAIL M**  
SCALE 2X



**SECTION N-N**  
SCALE 3X, 2 PL



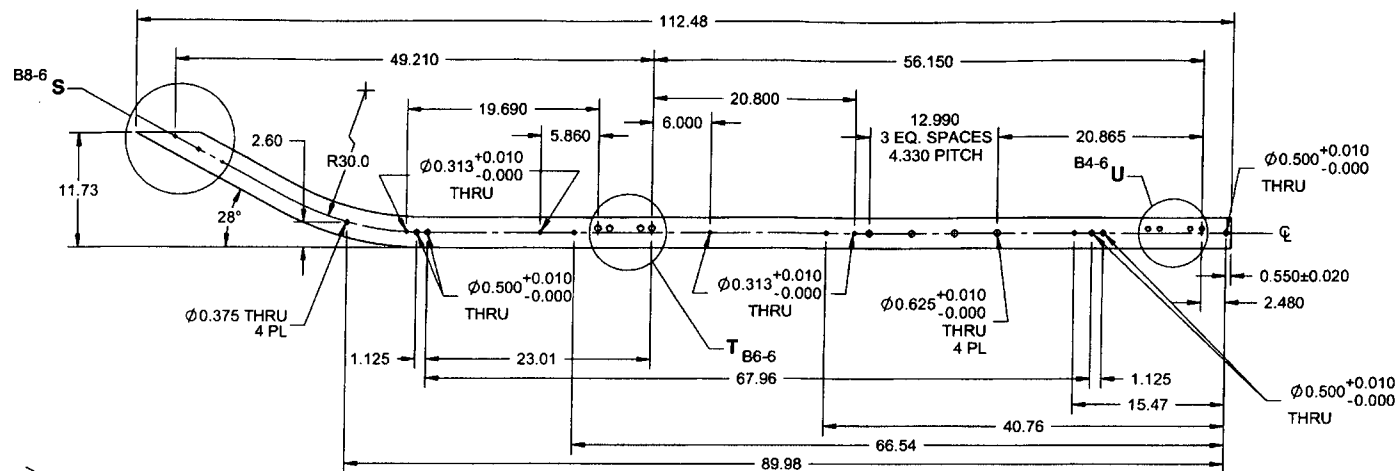
**SECTION Q-Q**  
SCALE 3X, 4 PL



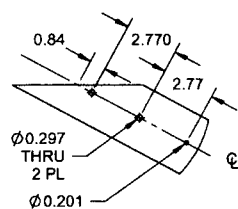
**SECTION R-R**  
SCALE 3X, 4 PL

**RELEASED**  
2013-08-13  
JMT

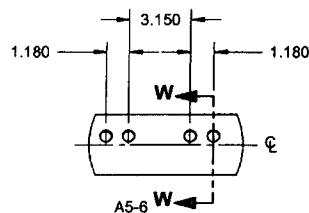
<b>DESIGN</b> <b>DRAWN</b> <b>CHECKED</b> <b>MFG. APPR.</b> <b>APPROVED</b> <b>DE APPR.</b> <b>DATE</b> 13.07.11		<b>DART AEROSPACE USA, INC.</b> KENT, WA <b>DRAWING NO.</b> D4168 <b>TITLE</b> 350 SKIDTUBE ASSEMBLY <small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	<b>REV. B</b> SHEET 5 OF 11 SCALE NTS
--	--	--	--



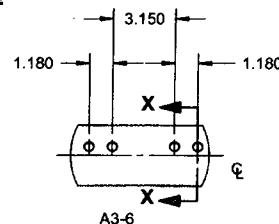
**D4168-3 LH SKIDTUBE**



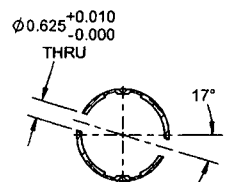
**DETAIL S**  
SCALE 2X



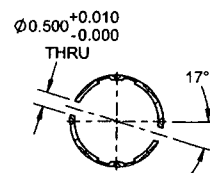
**DETAIL T**  
SCALE 2X



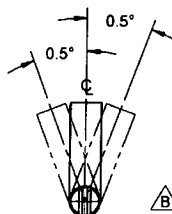
**DETAIL U**  
SCALE 2X



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL



MAX ALLOWABLE  
TWIST ON FWD BEND  
(VIEWED LOOKING FWD)

**RELEASED**  
2013-08-13

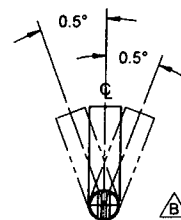
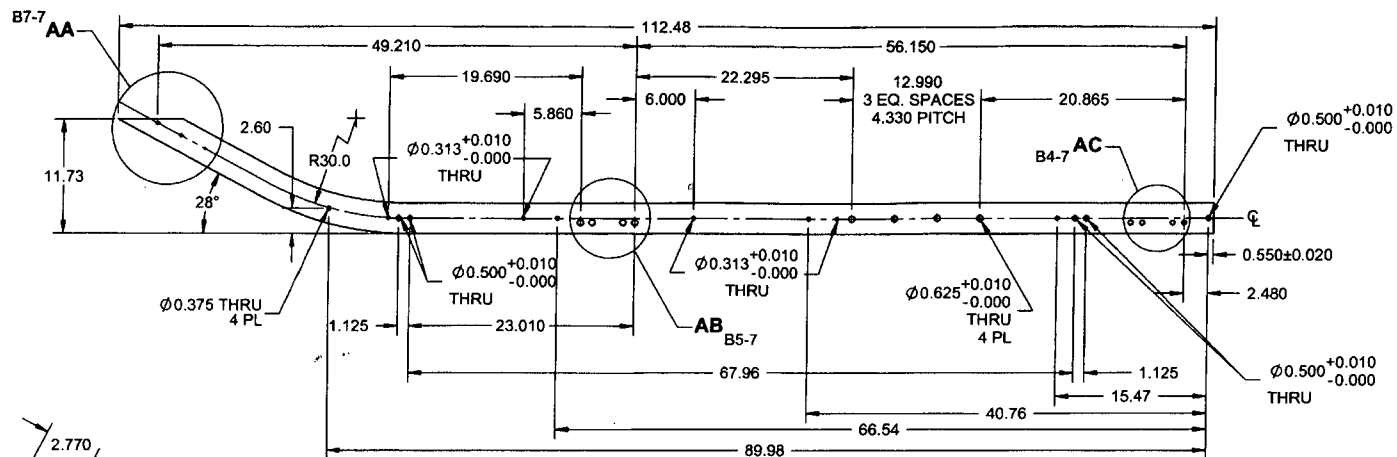
DESIGN  
DRAWN  
CHECKED  
MFG. APPR.  
APPROVED  
DE APPR.  
DATE 13.07.11

**DART AEROSPACE USA, INC.**  
KENT, WA

DRAWING NO.  
**D4168**  
TITLE  
**350 SKIDTUBE ASSEMBLY**  
REV. B  
SHEET 6 OF 11  
SCALE  
NTS

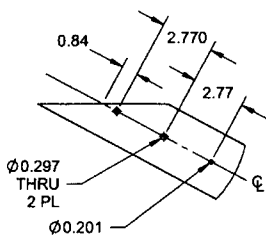
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8 7 6 5 4 3 2 1

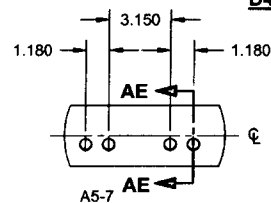


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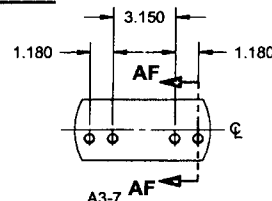
MAX ALLOWABLE  
TWIST ON FWD BEND  
(VIEWED LOOKING FWD)



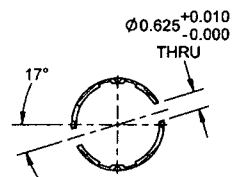
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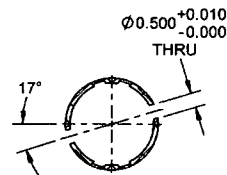
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**DETAIL AC**  
SCALE 2X



**SECTION AE-AE**  
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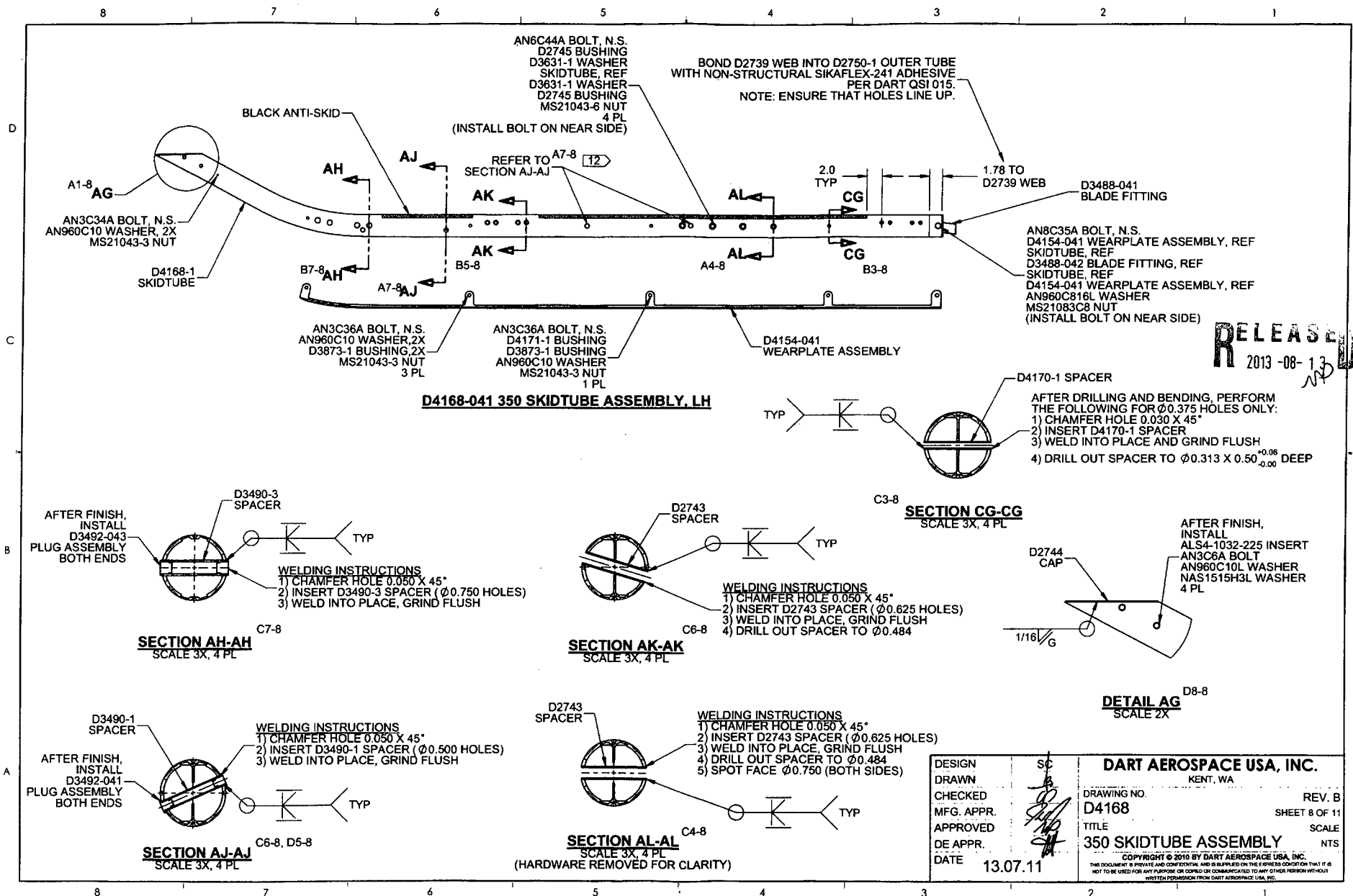


**SECTION AF-AF**  
SCALE 3X, 4 PL

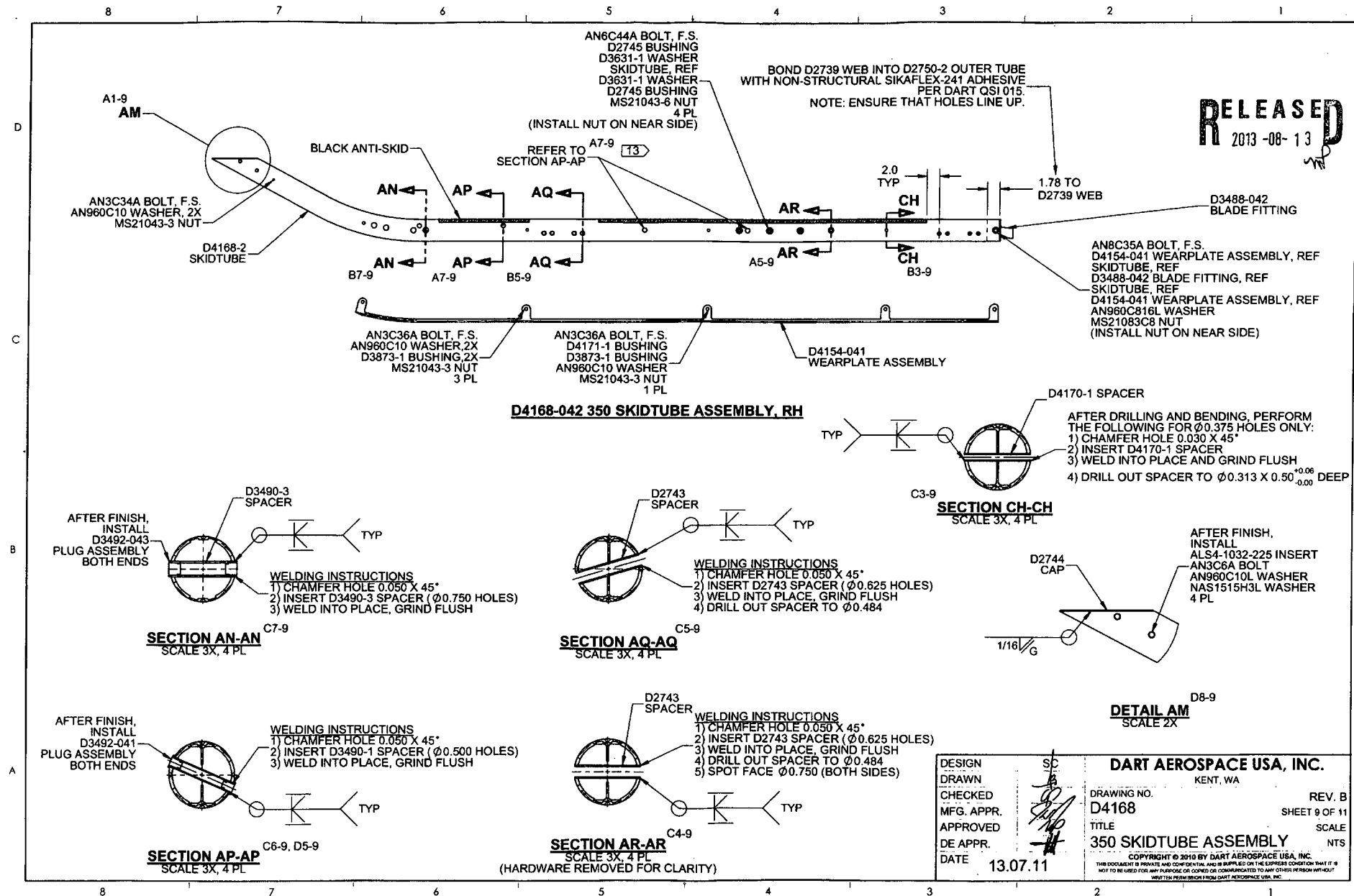
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2013-08-13  
JMP

<b>DESIGN</b> DRAWN CHECKED MFG. APPR. APPROVED DE APPR. DATE 13.07.11		SC 	<b>DART AEROSPACE USA, INC.</b> KENT, WA DRAWING NO. D4168 TITLE 350 SKIDTUBE ASSEMBLY <small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	REV. B SHEET 7 OF 11 SCALE NTS
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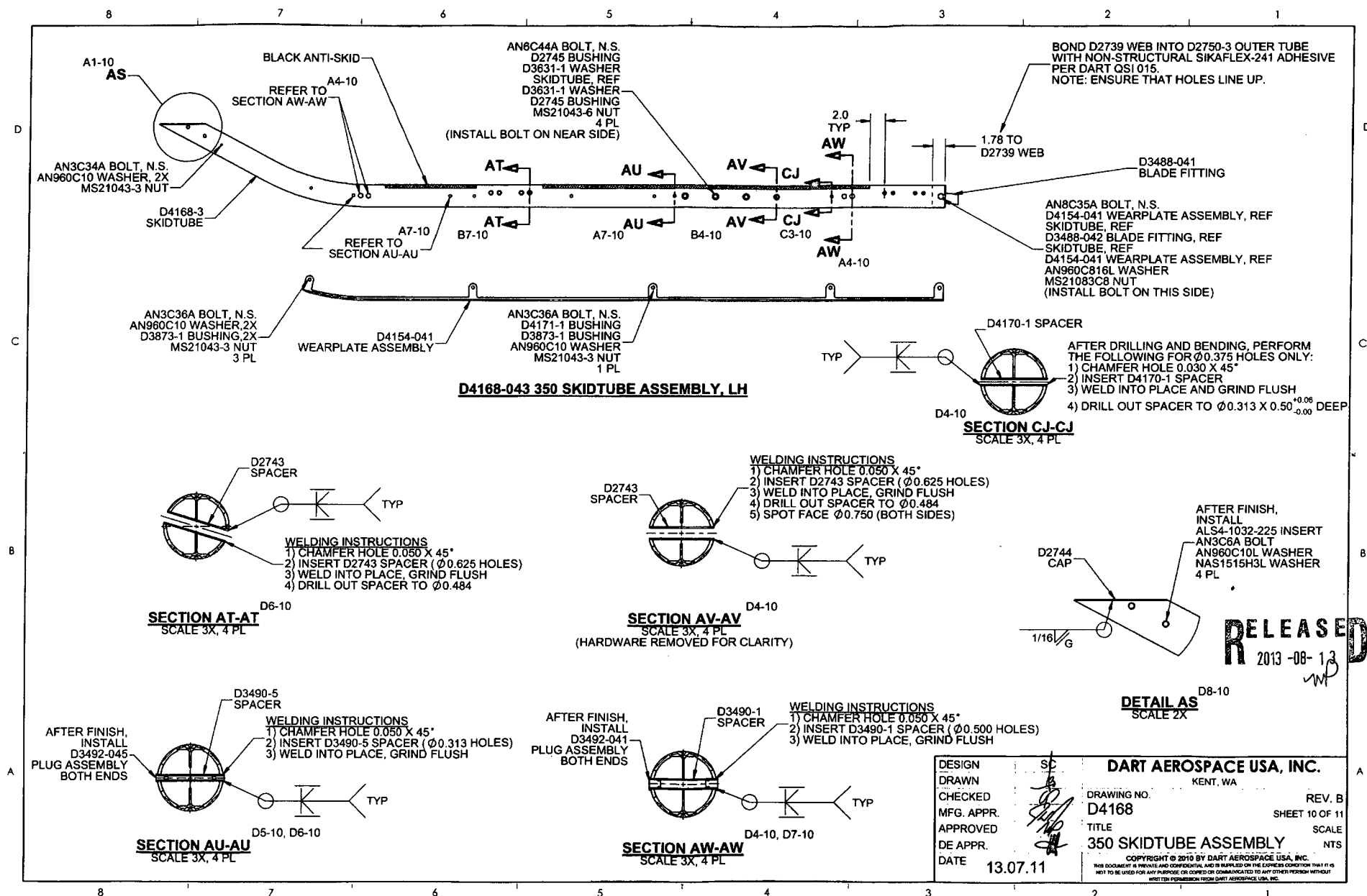
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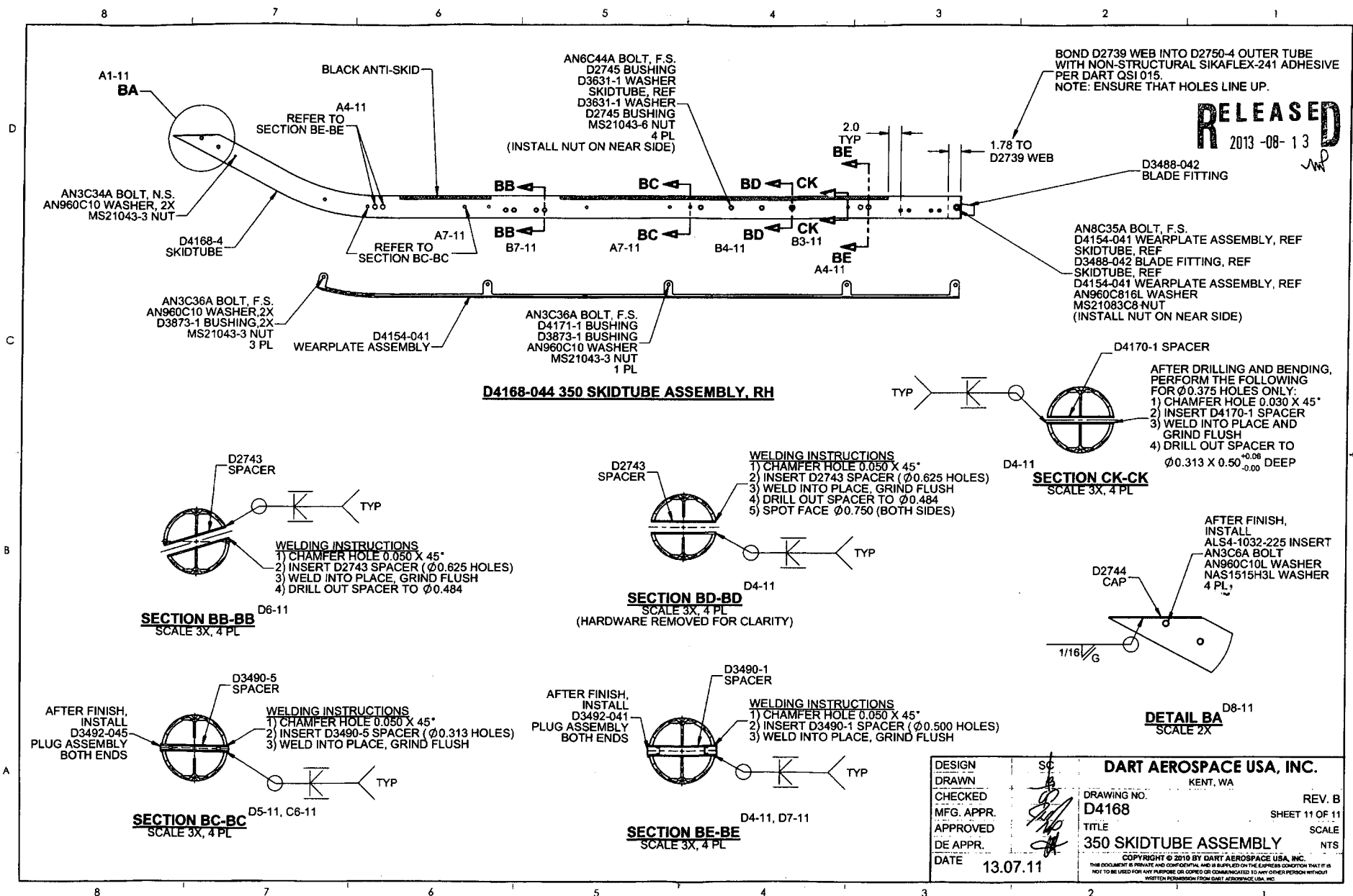


**RELEASED**  
R 2013-08-13









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*PAR 14-338*

Patrick Smith  
May-29-14 1:29 PM  
Linda Lacelle; Mike Petsche  
Nigel Forbes; Eric Downing; Nancy MacLeod; David Shepherd  
RE: 350 skids and 206 skids

*02/29/14*

*No other  
NER to  
fill out + as  
far as used?*

David and he would allow us to use a RTV product to bond the Plugs into the Skidtube.

Plugs would require:  
oval from the Skidtube  
oval of the current O-Ring  
ning with Alcohol  
allation of NEW O-Ring  
erous coating of the RTV  
rtion of plug into the Spacer  
in up of exterior of Skidtube.

a Lacelle  
29-14 10:21 AM  
tsche  
rbes; Patrick Smith; Eric Downing; Nancy MacLeod  
50 skids and 206 skids  
e: High

terday that plugs were falling out. Today we were told that we cannot ship any 350 skids. We have an order to ship today, has there been a solution  
this problem? Can we not just sikaflex them in or something? We need to let the customer know if his order is shipping or not...

*AS*

## Linda Lacelle

---

**From:** David Shepherd  
**Sent:** June-24-14 1:00 AM  
**To:** Chris Provencal  
**Cc:** Mike Petsche; Linda Lacelle  
**Subject:** RE: plugs on skidtubes

Chris,

Sorry for the delay in getting back to you on this.

If these are the only plugs that we are having a problem with, then I am OK with leaving them out of the skidtubes since the holes that are being plugged are so small. Seems weird to me that we've suddenly started to have a problem, but whatever.

Can I assume from your email that the rest of the plugs are OK?

Regards,  
David

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**From:** Chris Provencal  
**Sent:** June-04-14 10:59 AM  
**To:** David Shepherd  
**Cc:** Mike Petsche  
**Subject:** RE: plugs on skidtubes

David,

When installing D3492-045 plugs into the 3/16" holes for D4168-043 Skidtubes (AS 350), the o-rings are ripping. See the attached photos for one of the plugs. The effected hole is section AU-AU from the attached pdf page. This is causing some of the plugs to fall out when handling them.

I tried a new plug (D3492-5) and new o-ring (NAS1611-005) with an unpainted D3890-5 spacer (0.197 ID) and could not get it installed without the same ripping. We enlarged a spacer to 0.206" ID and put a 0.220"x45deg c'sink (about the OD of the o-ring) hoping it would force the o-ring into the hole. It ripped less, but the o-ring just doesn't want to compress that much. Some of the o-ring always wants to squeeze out and it gets sheared off when you try to force the plug in (it takes a lot of force to get it in).

I don't know how we've been doing this in the past. We only noticed the problem this time during final packaging of the latest batch.